

# Work Order ID 76758

**\*76758\***

Page 1

November-21-11 10:29:30 AM

Item ID: D2654-1

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Web

Start Date: 21/11/2011 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 02/01/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/11/21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2654	F

100

0.00

**\*100\***

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-5 to length as per Dwg D2654  
2-Drill pilot holes in web using drill jig DT 8018-1 as per Dwg D2654  
3-Using the uni-bit, open holes to finish size as per Dwg D2654  
4-Debur holes and ends

110

QC5- Inspect part completeness to step on W/O

0.00

**\*110\***

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

**\*120\***

HandFinish

Memo

0.00

Hand Finishing

10

11/12/28

10

11/12/28

10

11-12-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 76758







**\*76758\***

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November-21-11 10:29:30 AM

Item ID: D2654-1      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
 Revision ID:      Stop **\*NS2\***  
 Item Name: Web  
 Start Date: 21/11/2011      Start Qty: 10.00      **\*10\***      Cust Item ID:  
 Required Date: 02/01/2012      Req'd Qty: 10.00      **\*10\***      Customer:  
 Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
 QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				12-1-2			
140 <b>*140*</b> Packaging Packaging	Identify as per dwg & Stock Location:   Memo	0.00  0.00				12-1-2			
150 <b>*150*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00				CK 12/01/04			 12-01-03

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**NOTE:** Date & initial all entries

# Picklist Print

November-21-11 10:29:34 AM

Page 1

Work Order ID: 76758

\*76758\*

Parent Item: D2654-1

\*D2654-1\*

Parent Item Name: Web

Start Date: 21/11/2011

Required Date: 02/01/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedure DM  
IPP Rev:E 08-06-10 revE1 as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-5-108

Manufactured

No

100

Each

261.0000

1

10

\*\*

10

B 11/12/28 \*

\*D2600-5-108\*

Extrusion 'I Beam' thin

D 2600-50&0

Location

B 73867

Loc Qty

Loc Code

LG

261

47814

20

73909

241

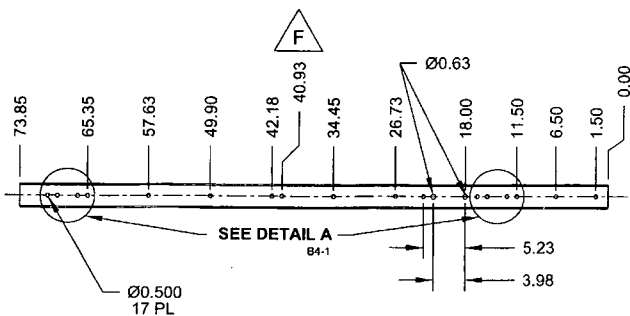
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

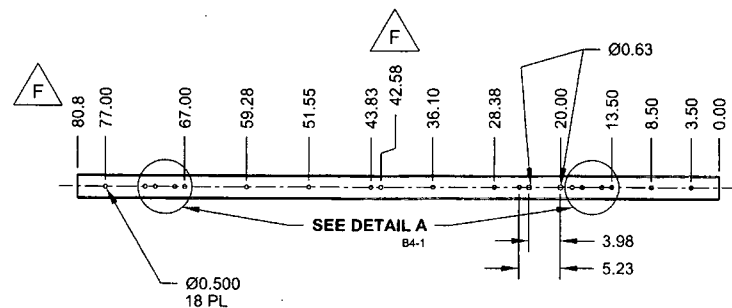
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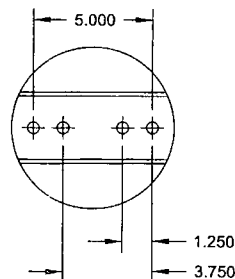
**NOTE:** Date & initial all entries



**D2654-1 WEB**



**D2654-3 WEB**



**DETAIL A**

C2-1  
C3-1  
C6-1  
C8-1  
D3-2  
D6-2  
B3-2  
B6-2

SHOWN BY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 70750 M.L.J.  
11/11/21

RELEASED  
2011-09-12

**NOTES:**

- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs  
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2	SC	11.05.05
E	CHANGE LENGTHS, REFORMAT	CP	04.05.26
D	GHW HOLES CHANGED TO Ø0.63	CP	98.01.15
C	CHANGED HOLE PATTERN	CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438	CP	97.06.26
A	NEW ISSUE	CP	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	9	DRAWING NO.	REV. F
MFG. APPR.	E	D2654	SHEET 1 OF 2
APPROVED	9	TITLE	SCALE
DE APPR.	9	WEB	NTS
DATE	11.05.05	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

**Dart Aerospace Ltd**

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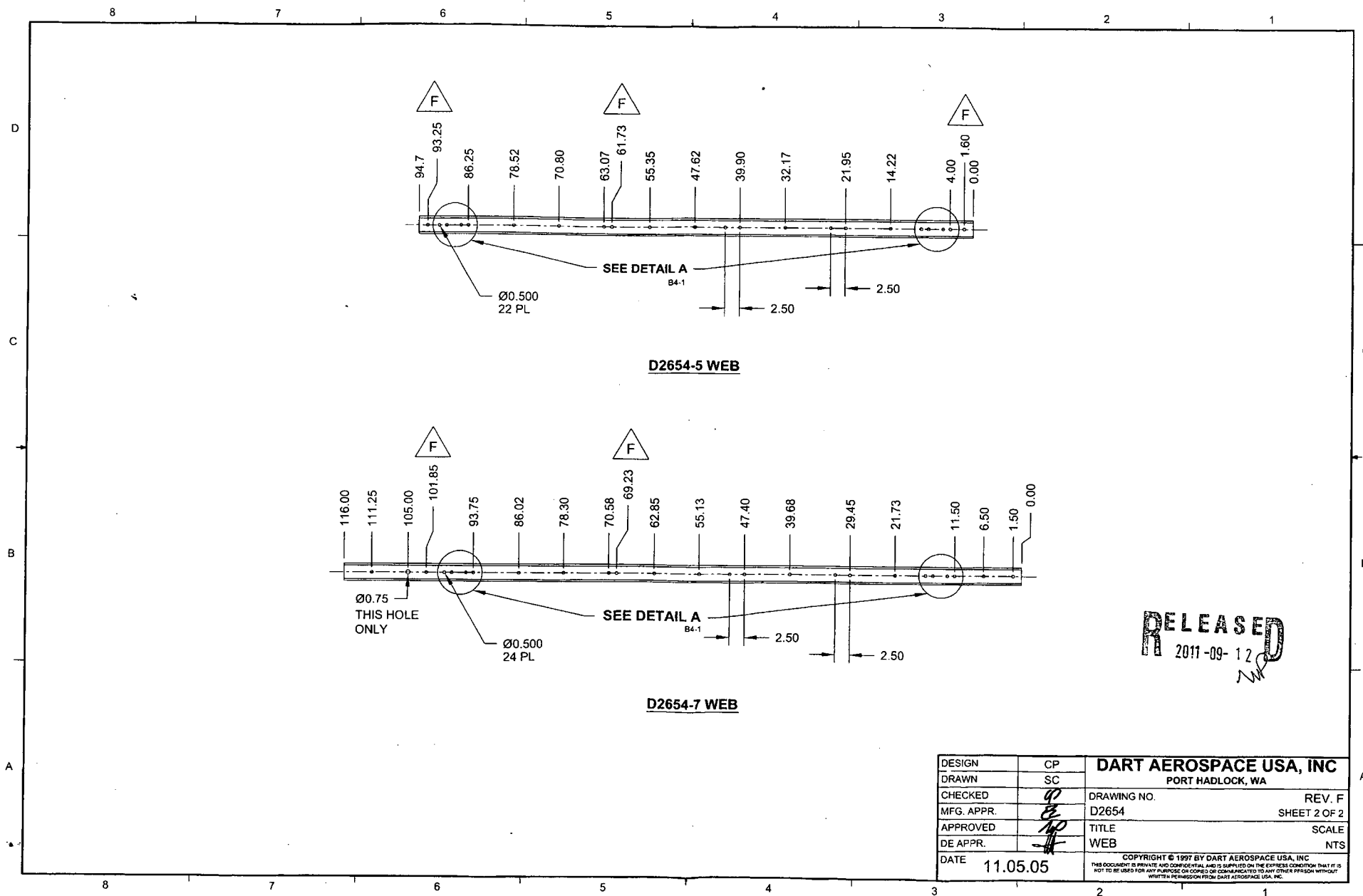
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76750



RELEASED  
2011-09-12  
JW

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	DP	DRAWING NO.	REV. F
MFG. APPR.	EP	D2654	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JH	WEB	NTS
DATE	11.05.05	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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